CCS Technical Documentation
RH-42 Series Transceivers

Assembly

 ©Nokia Corporation

©Nokia Corporation

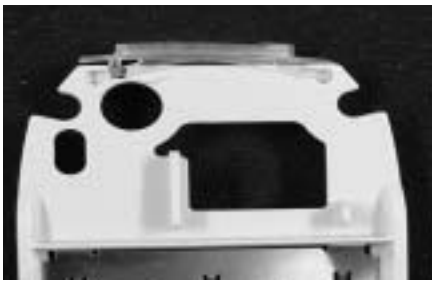
Assembling the RH-42 Basic Transceiver

1.

Assemble the D-cover assembly.

Step 1. Assemble the metal deck from the back cover side by pressing it with your fingers.

All six tabs should snap into the slots in the D-cover.



2.

Step 2. Place the IR window onto the D-cover before assembling the antenna.

Step 4. Press the antenna into its place.

Note: Make sure that the antenna springs do not get damaged or touched during assembly. No fingerprints should get on the springs.

3.

4.

Step 5. Place one end of the battery latch into the D-cover slot.

Step 6. Bend the latch and move the other end into the D-cover slot.

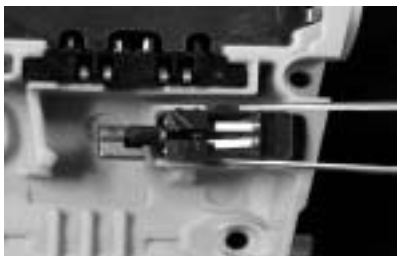
The battery connector will be assembled onto the D-cover with interference fixing.

5.

Step 7. Place connector onto D-cover with tweezers.

Step 8. Push the connector into the D-cover slot with your fingers.

Note: Make sure that the battery connector is below the D-cover edges after assembly. If the buzzer or vibra assembly is in place, make sure that the buzzer springs stay intact. They may be damaged, if touched.



6.

Step 9. Place the vibra assembly into its slot. Use tweezers.
The vibra is assembled into the D-cover with interference fixing.

Note: If the battery connector or the buzzer assembly is in place, make sure that the battery connector springs and the buzzer springs stay intact. The springs may be damaged, if touched.

7.

Step 10. Place the buzzer assembly into its place. Use tweezers.

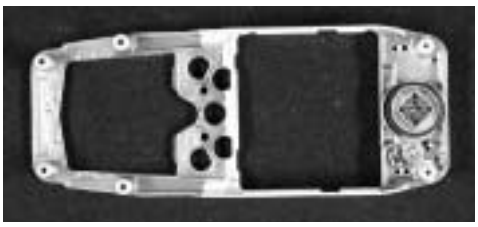
The buzzer is assembled into the D-cover with interference fixing.

8.

Step 11. Place the release spring into the D-cover slot.

The release spring is attached onto the D-cover with screws that are used for attaching the C- and D-covers. No heat staking is needed.

Assemble the C-cover.

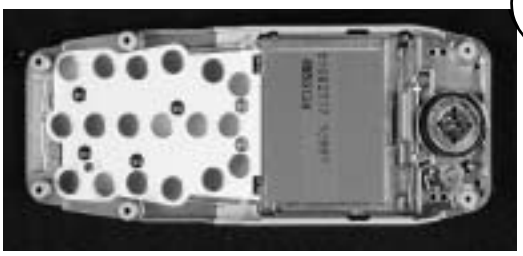


9.

Step 1. Check the condition of the screw holes. If they are worn out, change the cover.
Step 2. Place the C-cover into a jig. Make sure that the speaker with the speaker gasket is in place.

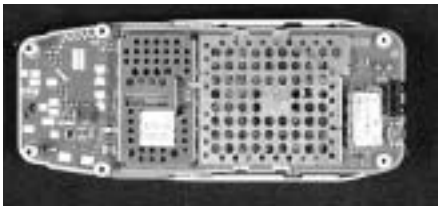
Note: Make sure that the speaker springs stay intact. They may be damaged, if touched.

Place the LCD module onto the C-cover.



10.

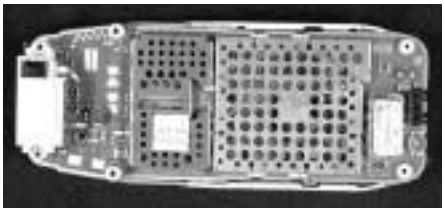
Note: The use of gloves or a vacuum picker is required, in order to prevent fingerprints from appearing on the LCD. Make sure that the elastomer connector and domes stay intact during assembly. Use compressed air or a vacuum before assembling the D-cover, in order to prevent dust from getting onto the engine layout.



11.

Place the engine module on top of the LCD module.

Note: The use of gloves is mandatory in order to prevent fingerprints from appearing on the engine layout. Use ionized air or a vacuum, before assembling the D-cover, to remove dust and other foreign particles from the PWB assy.



12.

Place the system connector on top of the engine module.

Note: The use of gloves is mandatory in order to prevent fingerprints from appearing on the engine layout and system connector pads (charging pads). Make sure that the system connector springs stay intact. The springs may be damaged, if touched.

Assemble the D-cover assembly.

13.

Step 1. Place the assembled D-cover on top of the C-cover.
Step 2. Press the D-cover to snap the side locks.

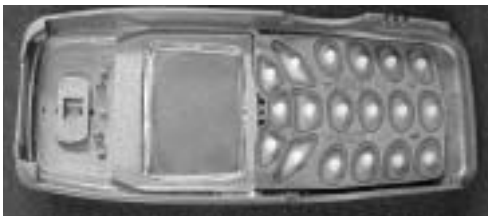
14.

Assemble the screws.

Step 1. Fasten the 6 screws. The assembly order is shown in the disassembly section. The torque is 20 - 21 Ncm 350/RPM.

Assemble the keymat onto the front cover.

15.



Step 1. Place the keypad onto the front cover before the cover is assembled to the basic transceiver.
Step 2. Press the keypad into its place.

16.

Assemble the front cover onto the basic transceiver.

Step 1. First push the basic transceiver to the front cover's IR window.

Step 2. Press the bottom part onto the front part, so that it snaps onto the front cover.

17.

Assemble the battery.

Step 1. Push the battery connector interface.

Step 2. Press the battery down so that the latch fits the battery in place.

Assemble the back cover.

18.

Step 1. Place the back cover on the phone.

Step 2. Slide the cover so that the spring snaps the cover into place.